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मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

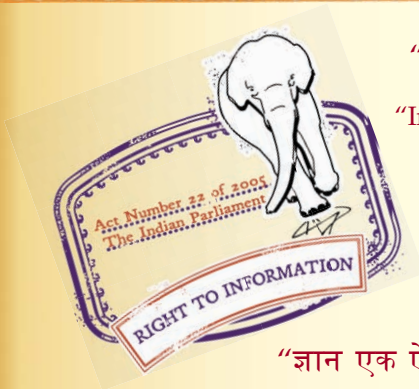
“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 896 (1991): Handloom woollen kamblies, loomstate [TXD 8: Handloom and Khadi]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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भारतीय मानक
हथकरघा निर्मित ऊनी लूमस्टेट (कोरी) कम्बलियाँ
(पहला पुनरीक्षण)

Indian Standard

HANDLOOM WOOLLEN KAMBLIES,
LOOMSTATE

(First Revision)

UDC 677·626·677·31·064 (083·75) (54)

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

This standard was first issued in 1957. It has now been revised in order to overcome certain difficulties encountered by the handloom industry in its implementation. Following are the important changes carried out while revising this standard:

- a) Only negative tolerances have been specified on ends/dm, picks/dm and mass to ensure minimum desirable construction. There being no tolerance on positive side on these requirements, it would provide flexibility to industry to adjust construction of the fabric depending upon market demands.
- b) Tolerances on length and width have been adopted from the instructions issued by the Central Government under the *Trade and Merchandise Marks Act 1958 (43 of 1958)* as given in *Notification No. S.O. 2937 dated 20 September 1962*.
- c) For determining the conformity of the kamblies to the requirements laid down in this standard, a provision has been incorporated to allow testing of specimens in prevailing atmospheric conditions. However, in all cases of disputes, the specimens are to be tested after conditioning in the standard atmospheric conditions.
- d) Provision has been incorporated for agreement between the buyer and the seller with respect to the permissible number of defects in the cloth.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (revised)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

HANDLOOM WOOLLEN KAMBLIES, LOOMSTATE

(First Revision)

1 SCOPE

1.1 This standard prescribes constructional particulars and other requirements for two varieties of handloom woollen kambliies, loomstate.

1.2 This standard does not specify general appearance, feel, etc. of the kambliies.

2 REFERENCES

The Indian Standards listed in Annex A are necessary adjuncts to this standard.

3 ATMOSPHERIC CONDITIONS FOR TESTING

Test specimens may be conditioned and tested in the prevailing atmosphere for determining the conformity of the material to this standard. However, in all cases of disputes, the specimens shall be conditioned and tested in the standard atmosphere as specified in the referred Indian Standards on test methods.

4 MANUFACTURE

4.1 Yarn

4.1.1 The yarn used in the manufacture of the kambliies shall be free from admixture of non-woollen fibre and shall be such that the cloth produced complies with the requirements of this standard.

4.1.2 The approximate count of the yarn is given in Table 1 for guidance.

4.2 Cloth

4.2.1 Variety No. 1 of the kambliies shall be woven in plain weave and Variety No. 2 in 2/2 twill weave.

4.2.2 The transverse ends of the kambliies shall be finished off with a fringe of approximately 65 mm length.

5 REQUIREMENTS

5.1 The kambliies shall conform to the requirements specified in Table 1.

5.2 Scouring Loss

The scouring loss of the kambliies, when determined as prescribed in Annex C, shall not exceed 15 percent.

5.3 Dimensions

The length and width of the kambliies, when determined in accordance with IS 1954 : 1990, shall be as agreed to between the buyer and the seller or as declared by the seller subject to the tolerances specified in the *Government of India, Ministry of Commerce and Industry Notification No. S.O. 2937 dated 20 September 1962* issued under the *Trade and Merchandise Marks Act 1958 (43 of 1958)* (see Annex D).

**Table 1 Constructional Particulars and Breaking Load
Requirements for Handloom Woollen Kambliies, Loomstate**
(Clauses 4.1.2 and 5.1)

Variety No.	1) Approximate Count of Yarn: Universal Count 2) (Woollen Count)		Ends/dm	Picks/dm	Mass	Breaking Load on 15 × 20 cm Strips	
	Warp	Weft				Warpway	Weftway
(1)	(2)	(3)	(4)	(5)	(6) g/m ²	(7) N	(8) N
1	430 tex (4.5 s)	310 tex (6.25 s)	70	35	425	1 235	568
2	258 tex (7.5 s)	310 tex (6.25 s)	100	65	475	1 335	882
Tolerance, percent	—	—	—5	—5	—5	—5 on average value and —15 on individual reading	
Method of Test	—	—	IS 1963 : 1981	IS 1964 : 1970 or Annex B	IS 1969 : 1985		

1) For guidance only.

2) Yorkshire.

5.4 Sealed Sample

If in order to illustrate or specify the indeterminate characteristics such as general appearance, feel and shade, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

6 VISUAL INSPECTION

6.1 The kambliies when visually inspected should be free from major flaws listed in Annex E.

The number of permissible major flaws per unit length or per piece shall be agreed to between the buyer and the seller.

6.2 For details of the flaws mentioned in 6.1, reference may be made to IS 4125 : 1987.

7 MARKING

7.1 The kambliies shall be suitably marked with the following information:

- a) Name of the material and variety No.,
- b) Length (cm) and width (cm), and
- c) Indication of the source of manufacture.

7.2 The kambliies may also be marked with the Standard Mark.

8 PACKING

Unless otherwise agreed upon by the buyer and the seller, the kambliies shall be packed in bales or cases in accordance with the procedure laid down in IS 32 : 1971 or IS 741 : 1971.

9 SAMPLING

9.1 Lot

The quantity of kambliies delivered to one buyer against one despatch note shall constitute a lot.

9.2 The conformity of a lot to the various requirements specified in the standard shall be determined on the basis of tests carried out on the samples selected from it.

9.3 Unless otherwise agreed, the number of pieces to be selected at random for inspection shall be in accordance with Table 2. For random selection of samples, IS 4905 :1968 may be followed.

Table 2 Sample Size and Permissible Number of Non-conforming Pieces
(Clauses 9.3 and 9.4)

Lot Size	Sample Size	Permissible Number of Non-conforming Pieces	Sub-sample Size
(1)	(2)	(3)	(4)
Up to 25	3	0	2
26 to 50	5	0	2
51 to 150	8	0	3
151 to 300	13	1	3
301 to 500	20	1	5
501 to 1 000	32	2	5
1 001 to above	50	3	8

9.4 Number of Samples and Criteria for Conformity

The number of samples to be drawn and the criteria for conformity of the material for various characteristics shall be as follows:

Characteristics	Number of Samples	Criterion for Conformity
Ends, picks, mass, length, width and visual inspection	According to col 2 of Table 2	Number of non-conforming pieces shall not exceed the corresponding number given in col 3 of Table 2
Scouring loss and breaking load	According to col 4 of Table 2	All the pieces shall meet the requirement

ANNEX A

(Clause 2)

LIST OF REFERRED INDIAN STANDARDS

IS No.	Title	IS No.	Title
32 : 1971	Code for seaworthy packaging of woollen and worsted yarn and cloth (<i>second revision</i>)	1964 : 1970	Methods for determination of weight per square metre and weight per linear metre of fabrics (<i>first revision</i>)
741 : 1971	Code for inland packaging of woollen and worsted yarn and cloth (<i>first revision</i>)	1969 : 1985	Methods for determination of breaking load and elongation of woven textile fabrics (<i>second revision</i>)
1954 : 1990	Methods for determination of length and width of woven fabrics (<i>second revision</i>)	4125 : 1987	Glossary of terms pertaining to defects in fabrics (<i>first revision</i>)
1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)	4905 : 1968	Methods for random sampling

ANNEX B

(Table 1)

METHOD FOR DETERMINATION OF MASS OF FABRIC

B-1 Cut four specimens of 100 mm × 100 mm each from a sample. Condition all the specimens in a desiccator charged with saturated solution of sodium nitrate at $27 \pm 2^\circ\text{C}$ for a period of 24 hours. Remove all the specimens from the

desiccator and immediately determine their collective mass in weighing balance to the nearest milligram.

B-2 Calculate the mass of the fabric in g/m².

ANNEX C

(Clause 5.2)

METHOD FOR DETERMINATION OF SCOURING LOSS

C-1 TEST SPECIMEN

Take about 10 g of yarn from the sample to be tested. This shall constitute a test specimen.

C-2 PROCEDURE

C-2.1 Dry the test specimen to constant mass in a drying oven at $105 \pm 3^\circ\text{C}$ and determine its mass accurately.

NOTE — Constant mass shall be deemed to have been reached if the difference between the two successive weighings at an interval of 20 minutes is less than 0.05 percent.

C-2.2 Extract the specimen with a mixture of benzene and methyl alcohol in the proportion of 3 : 2 in a Soxhlet apparatus for 4 hours at the

rate of 5 extractions per hour, taking care to place the specimen in a thimble and covering it with cotton-wool previously extracted with petroleum hydrocarbon solvent (petroleum ether).

C-2.3 Remove the specimen after extraction. Dry the residue to constant mass (*see* Note under **C-2.1**) at $105 \pm 3^\circ\text{C}$ and determine its mass accurately.

C-3 CALCULATION

$$\text{Scouring loss, percent} = \frac{m_2}{m_1} \times 100$$

where

m_2 = mass of the dried residue (**C-2.3**), and
 m_1 = mass of the test specimen (**C-2.1**).

ANNEX D
(Clause 5.3)

**EXTRACTS FROM THE GOVERNMENT OF INDIA, MINISTRY OF
COMMERCE AND INDUSTRY (TRADE AND MERCHANDISE MARKS)
NOTIFICATION NO. S.O. 2937 DATED 20 SEPTEMBER 1962**

- 1) *A trade description of length and width on woollen (including shoddy) and worsted fabricated items like blankets, shawls, scarves or other articles of a similar kind:*
 - i) The actual length of the piece shall not be less than the stamped length by more than 1 percent, and
 - ii) The permissible limits of variation in respect of trade description of width shall be as those prescribed for width of woollen and worsted piece goods [see item (2) below].
- 2) *A trade description of width stamped on worsted, woollen and shoddy piece goods:*
 - i) In pieces of worsted fabric, the stamped width shall not be greater or less than the actual width, provided that the variation in width at any point is not more than 2 percent and on average not more than 1.5 percent; and
 - ii) In pieces of woollen and shoddy piece goods, the stamped width shall not be greater or less than the actual width, provided that the variation in width at any point is not more than 3 percent and on average not more than 2 percent.

ANNEX E
(Clause 6.1)

LIST OF MAJOR FLAWS

- 1) One or more ends missing in the body of the material throughout its length, more than three ends missing at a place and running over 60 cm, or prominently noticeable double ends running throughout the piece.
- 2) Undressed snarls noticeable over a length exceeding 5 percent of the length of the piece.
- 3) Smash definitely rupturing the texture of the fabric.
- 4) Hole, cut or tear.
- 5) Reed marks prominently noticeable over a length exceeding 5 percent of the piece.
- 6) Defective or damaged selvedge noticeable over a length exceeding 5 percent of the length of the piece.
- 7) Skewing of weft.
- 8) Weft crack or two or more missing picks across the width of the fabric.
- 9) Warp or weft bar due to difference in raw material, count, twist, lustre, colour, shade or spacing of adjacent groups of yarns (starting mark).
- 10) More than two adjacent ends running parallel, broken or missing and extending beyond 10 cm.
- 11) Noticeable warp or weft float in the body of the fabric.
- 12) Noticeable oil or other stain in the fabric.
- 13) Oily weft in the fabric.
- 14) Prominently noticeable slub.
- 15) Conspicuous broken pattern.
- 16) Gout due to foreign matter, usually lint or waste, woven into the fabric.
- 17) Prominent selvedge defect.
- 18) Fuzzy appearance.

Standard Mark

The use of the Standard Mark is governed by the provisions of the *Bureau of Indian Standards Act, 1986* and the Rules and Regulations made thereunder. The Standard Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well defined system of inspection, testing and quality control which is devised and supervised by BIS and operated by the producer. Standard marked products are also continuously checked by BIS for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

Bureau of Indian Standards

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